

DUPLICATE

Dart Aerospace Ltd.

Date: Monday, 06/04/2009 11:40:27 AM
User: Linda Lacelle

Process Sheet

Ship 13/04

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 46463
Estimate Number : 10771
P.O. Number :
This Issue : 06/04/2009 S.O. No. :
Prsht Rev. : NC
First Issue : 11/03/2009 Type : LARGE FAB ASSY
Previous Run : 46141
Written By :
Checked & Approved By :
Comment : EST REV. A 05.11.18 NEW ISSUE EC
esr rev B 08.07.15 ecn 1049 EC verified by: DD

Drawing Name : BRACKET ASSEMBLY
Part Number : D3462042
Drawing Number : D3462 REV C
Project Number : N/A
Drawing Revision : C
Material :
Due Date : 20/03/2009 Qty: 5 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D34621 BRACKET ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Base Flat Pattern

Pick:

Qty	Part Number	Description	Batch
1	D3462-1	Base Flat Pattern	B46526

SP 09.04.06 4X

2.0 D34623 Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Flange

Pick:

Qty	Part Number	Description	Batch
1	D3462-3	flange	4x B46267

SP 09.04.06 4X

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld assembly as per dwg D3462

SP 09.04.06 4X

4.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

SP 09.04.07

(X4)

5.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SP 09/04/08 (X4)

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 46463

Part Number: D3462042

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



m110939



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

(4)

START TIME:

6:15

OVEN TEMPERATURE:

400°

FINISH TIME:

6:45

FL 09/04/09

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BL 09-04-9 (4)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 98A

9/4/9

(4)

SP

9.0

QC21

FINAL INSPECTION/W/O RELEASE



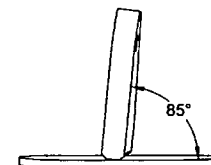
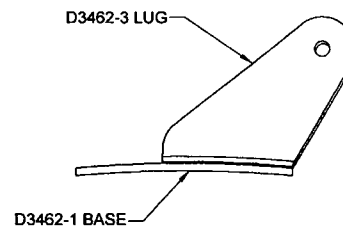
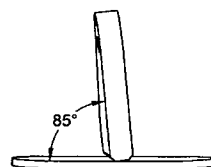
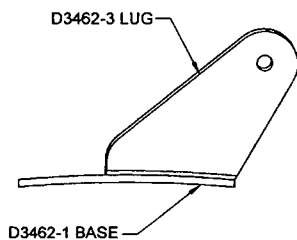
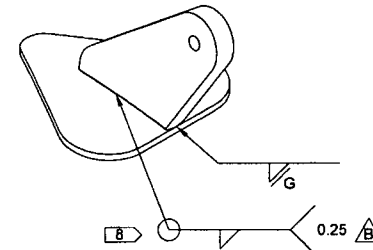
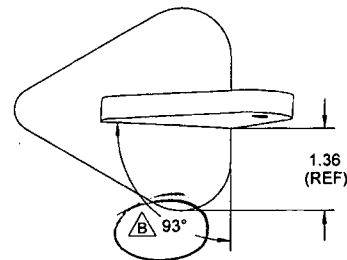
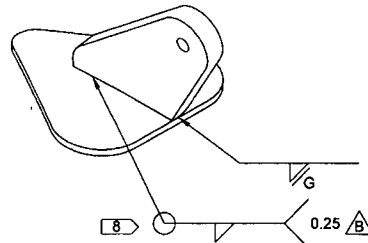
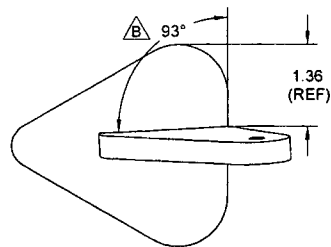
Comment: FINAL INSPECTION/W/O RELEASE

09/04/14

Job Completion



MF 09-04-09



D3462-041 BRACKET ASSEMBLY

D3462-042 BRACKET ASSEMBLY

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3462-041	BRACKET ASSEMBLY
	X	D3462-042	BRACKET ASSEMBLY
1	1	D3462-1	BASE
1	1	D3462-3	LUG

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3462-041" OR "D3462-042" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.75 lbs (TYP)
- 8) WELDING: PER DART QSI 004

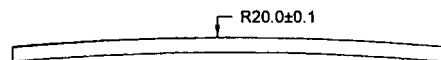
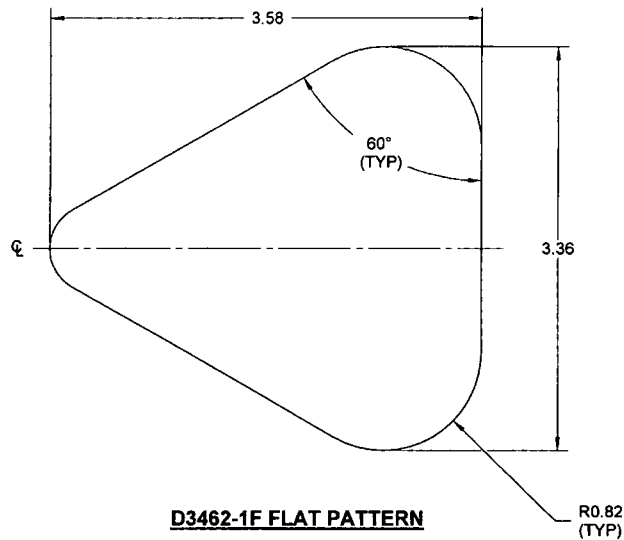
C	SHOW VIEWS OF D3462-041 & D3462-042, UPDATE DWG REASON: PRODUCTION FACILITY	DC	07.10.24
B	REVISE DIMENSIONS	RF	05.12.05
A	NEW ISSUE	RF	05.09.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.10.24		

FILE
060707 1420

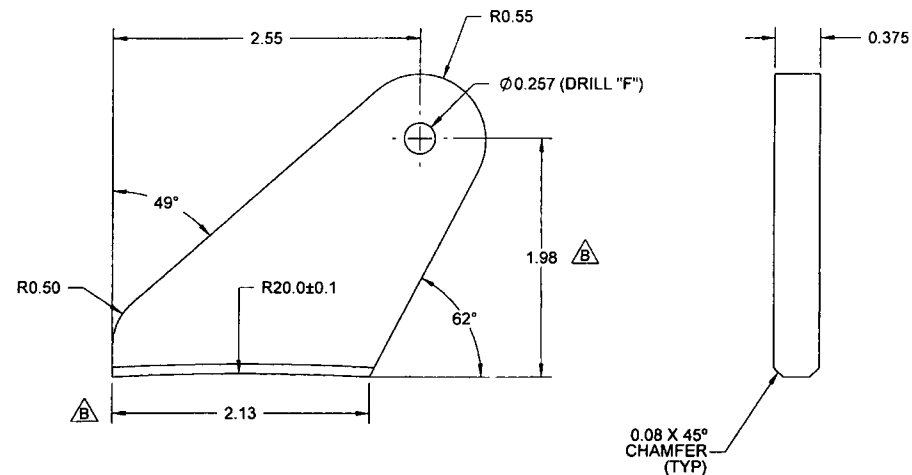
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3462** REV. C
TITLE **BRACKET ASSEMBLY** SCALE 1:2

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- NOTES:**
- 1) MATERIAL: AISI 304 SS SHEET, 0.125 THICK
PER MIL-S-5019 (ANNEALED), 2B FINISH
(REF. DART SPEC. M304S11GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.28 lbs



- NOTES:**
- 1) MATERIAL: AISI 304 SS BAR
(REF. DART SPEC M304B0.375X03.000)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.47 lbs

RELEASED
8-07-07

DESIGN	7	DART AEROSPACE LTD	
DRAWN	1/2 20.7.02	HAWKESBURY, ONTARIO, CANADA	
CHECKED	1/2	DRAWING NO.	REV. C
MFG. APPR.	1/2	D3462	SHEET 2 OF 2
APPROVED	1/2	TITLE	SCALE
DE APPR.	1/2	BRACKET ASSEMBLY	1:1
DATE	07.10.24	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	